

Date: Friday, 09/05/2008 1:45:19 PM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STRUT ASSEMBLY
<b>Job Number</b> :	39152		
<b>Estimate Number</b> :	10732		
<b>P.O. Number</b> :		<b>Part Number</b> :	D23241
<b>This Issue</b> :	09/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2324 REV. C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36749	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	05/06/2008
<b>Written By</b> :		<b>Qty:</b>	20 Um: Each
<b>Checked &amp; Approved By</b> :	JUL 08.5.09		
<b>Comment</b> :	Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	39152A	STOP
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Comment: Sub-Component STOP

D2324-3 B 36749A

CB08/05/12

2.0	39152B	STRAP
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Comment: Sub-Component STRAP

D2324-5 B 37631

CB08/05/12

3.0	AN312A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt M103947

(70)

M106605

(33x)

CB08/05/12

4.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer

M107715

CB08/05/12

5.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

M107644

CB08/05/12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:45:19 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 39152

Part Number: D23241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2324.

08/05/12

(20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/12 (20)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m/07550

(PB) →

START TIME:

10:50

OVEN TEMPERATURE:

~~320~~ 320

FINISH TIME:

11:20

FL 08/05/13

(20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/05/14 (420)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST 203

08/05/14

(20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/15

Job Completion



08/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

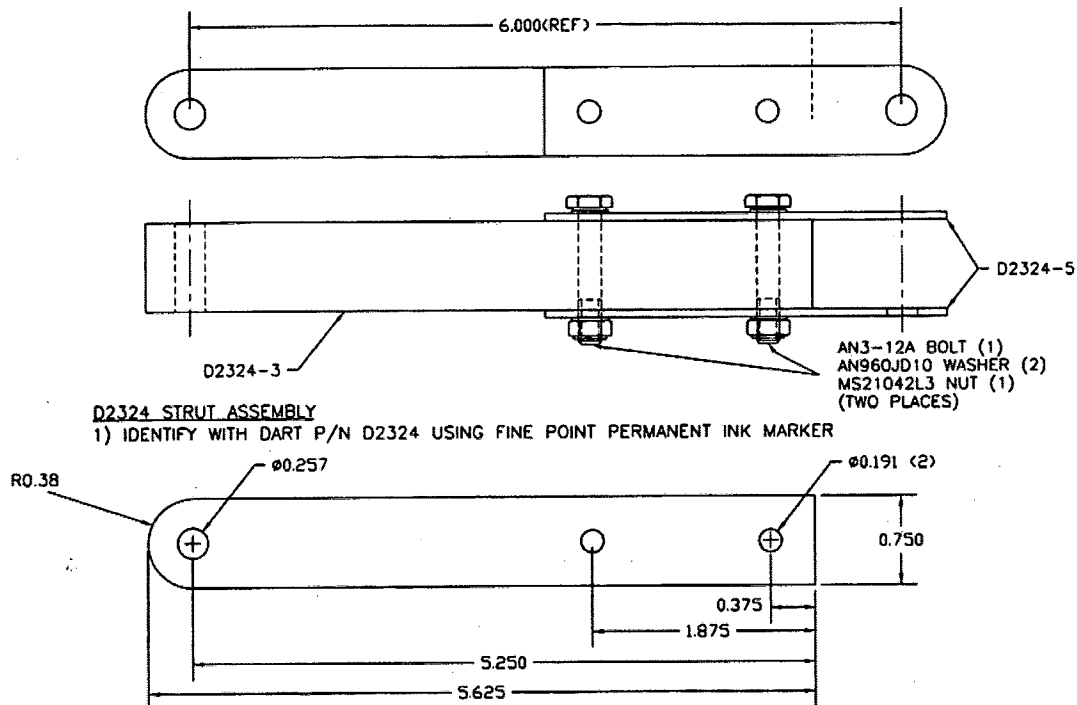
Part No: D2324-1 PAR #: NA Fault Category: Prod/Finishing NCR: Yes No DQA: D Date: 08/05/15  
 QA: N/C Closed: D Date: 08/05/15

NCR: <u>39152</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/13	8.0 6.0	During Powder coat inspection it was found that one strut has a large scratch on it.	Kosman	<del>Buff out</del> Buff out scratch	SJS 03/05/13	isolated	Kosman	08/05/13
				Re <del>Alodine</del> Alodine affected area Start time: 2:25 Temp: 320° Finish time: 2:55. Re Powder coat as per Q57005	SJS 08/05/13 08/05/13			
			Kosman	FRAN3-124 M106605 <del>FRAN3-124 M106605</del> FRAN3-124 M106605 Remove and Replace Hardware	SJS 09/05/13	08/05/14	Kosman	8/05/13

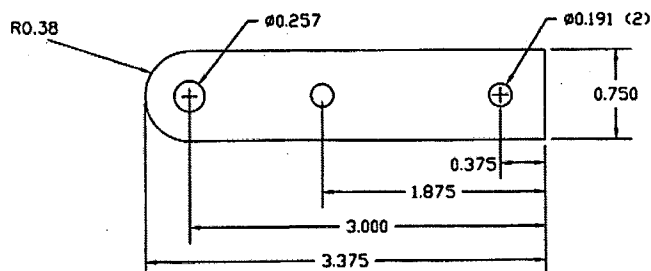
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

**RELEASED**04.12.16 *[Signature]***D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
**UNCONTROLLED COPY**  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 39152

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries